

Work Order ID 86764

86764

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July-06-12 2:19:46 PM

Item ID: D3016-041 Accept *N900040100* Setup Start *NS1*
 Revision ID:
 Item Name: Seat Frame Assembly Stop *NS2*
 Start Date: 7/06/12 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 8/17/12 Req'd Qty: 1.00 *1* Customer:

Reference:

Approvals: Process Plan: Date: 12079 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3016	RevA / DEO A-1

100 Weld per dwg A/R 4130 rod Batch: M118875 0.00
 100 Large Fab
 Memo 0.00
 1-Cut all tubes as per Dwg D3016
 2-Deburr
 3-Assemble tubes, fittings and weld as per Dwg D3016 using welding jig DT8597
 4-Transfer drill holes from D3017-041 and D3021-041 in seat frame D3016-041
 5- Assemble brackets and gusset per dwg and weld

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00
 110 QC Memo 0.00
 Quality Control



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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
130 *130* Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 Memo Install paint screws on fitting ends START TIME: 1:15 OVEN TEMPERATURE: 320 OF FINISH TIME: 1:45	0.00 0.00							
140 *140* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							

12/09/17
12/09/17
12/09/17

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <i>GA</i>	0.00				<i>1K</i>			<i>8/2/09/18</i>
150									
Packaging	Memo	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							<i>12/9/19</i>
160									
QC	Memo	0.00							
Quality Control									

1/12-09/18

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Comments: IPP A01.09.19New issueECIPP RevB: as per revB DD verified by:JLM

Required Date: 8/17/12

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M4130NT0.750W.049 4130 RD Tube .750 x.049W		Purchased	No			100	f	87.3900	4.3	4.5263158		12-9-5	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT033		87.39							
				120350		47.08							
				121025		40.31							
M4130NT0.500W.049 4130 RD Tube .500 x.049W		Purchased	No			100	t	38.9500	4.3	4.5263158		12-9-5	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT032		38.95							
				121025		38.95							
M4130NT1.000W.120 4130 RD Tube 1.00 x .120wall		Purchased	No			100	f	62.9500	1.5	1.5789474		12-9-5	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT033		62.95							
				117656		18.69							
				117973		44.26							
D3016-17 Gusset		Manufactured	No			100	Each	20.0000	2			12-9-13	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA021		20							
				70872		12							
				70909		8							
D3016-13 Bracket		Manufactured	No			100	Each	4.0000	2			12-9-13	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA021		4							
				76567		4							

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Picklist Print

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Work Order ID: 86764

Parent Item: D3016-041

Parent Item Name: Seat Frame Assembly

Start Date: 7/06/12

Required Date: 8/17/12

Start Qty: 1.00

Required Qty: 1.00

D3016-15	Manufactured	No	100	Each	6.0000	2	2	<u>12-9-13</u>
Gusset								

Location

Loc Qty

Loc Code

WA

6

77579

6

2

D3020-1	Manufactured	No	100	Each	16.0000	4	4	<u>12-9-10</u>
Fitting								

Location

Loc Qty

Loc Code

WA

13

85978

13

4

WA021

3

76579

3

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DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3016	REV. A SHEET 1 OF 3
DATE 01.05.18		TITLE SEAT FRAME ASSEMBLY	SCALE NTS
A	01.05.18	NEW ISSUE	

QTY	PART NUMBER	DESCRIPTION	MATERIAL
X	D3016-041	SEAT FRAME ASSEMBLY	N/A
1	D3016-1	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
2	D3016-3	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
1	D3016-5	TUBE	AISI 4130N TUBE, Ø0.50 DIA x 0.049 WALL (M4130N-T0500W049)
2	D3016-7	TUBE	AISI 4130N TUBE, Ø0.50 DIA x 0.049 WALL (M4130N-T0500W049)
1	D3016-9	SADDLE	AISI 4130N TUBE, Ø1.00 DIA x 0.120 WALL (M4130N-T1000W120)
1	D3016-11	SADDLE	AISI 4130N TUBE, Ø1.00 DIA x 0.120 WALL (M4130N-T1000W120)
1	D3016-13	BRACKET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
1	D3016-15	GUSSET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
1	D3016-17	GUSSET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
2	D3020-1	FITTING	N/A

NOTES

- 1) WELD PER DART QSI 004
- 2) ON SHEET METAL PARTS, BREAK ALL UNMARKED CORNERS 0.020-0.040
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WITHOUT NOTICE
WORK ORDER
NO. *86114*

2/12-079

DEO ATTACHED

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01.05.30 *#*

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Dart Aerospace Ltd

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

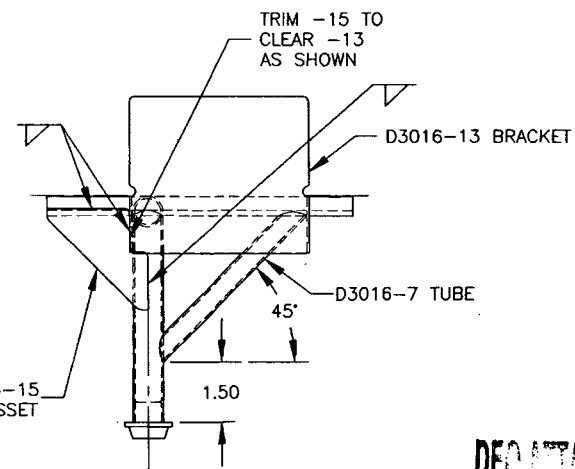
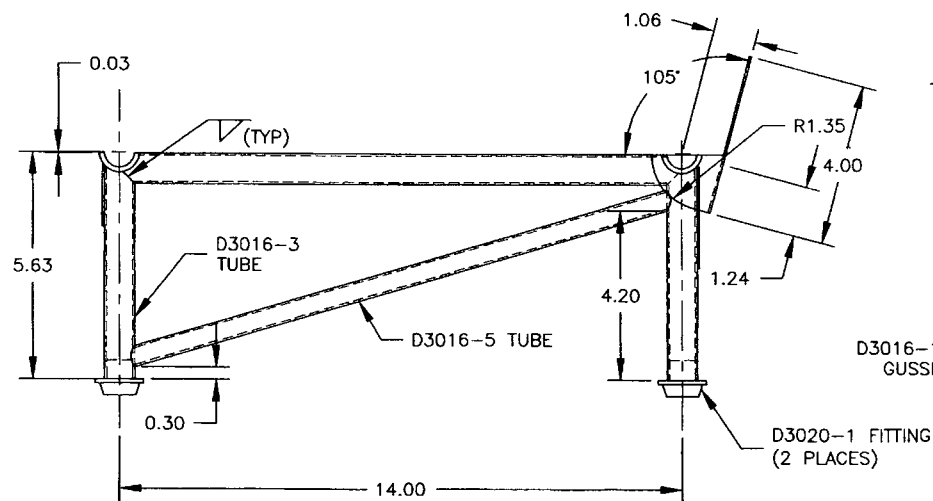
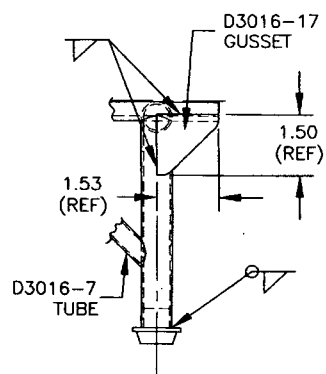
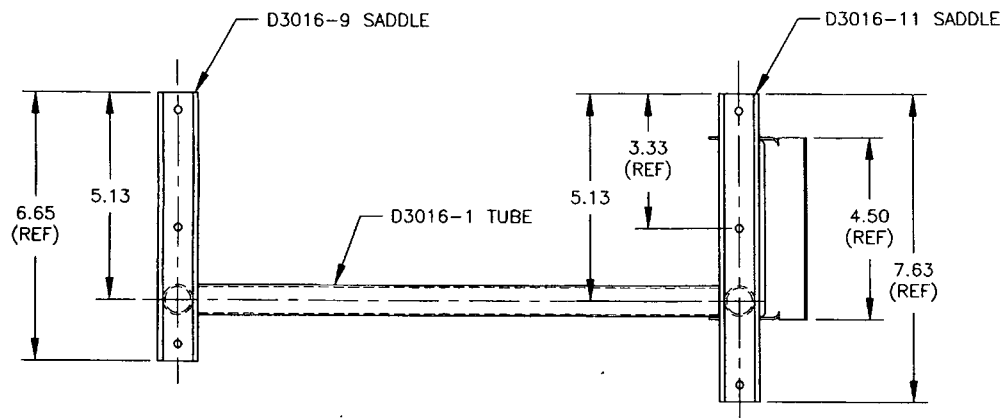
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D3016-041 SEAT FRAME ASSEMBLY



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DESIGN CP	DRAWN BY CP	DART	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED #	APPROVED #	DRAWING NO. D3016	REV. A SHEET 2 OF 3
DATE 01.05.18	TITLE SEAT FRAME ASSEMBLY	SCALE 1:3	

Dart Aerospace Ltd

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DRAWING NO. D3016	TITLE SEAT FRAME ASSEMBLY	REV. A	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO. D3016-A-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN 1	CHECKED JP	MFG. APPR. RE	APPROVED WAP	DE APPR. -H		
DATE 10.01.29	DATE 10.01.29	DATE 10.01.29	DATE 10.01.29	DATE 10.01.29		

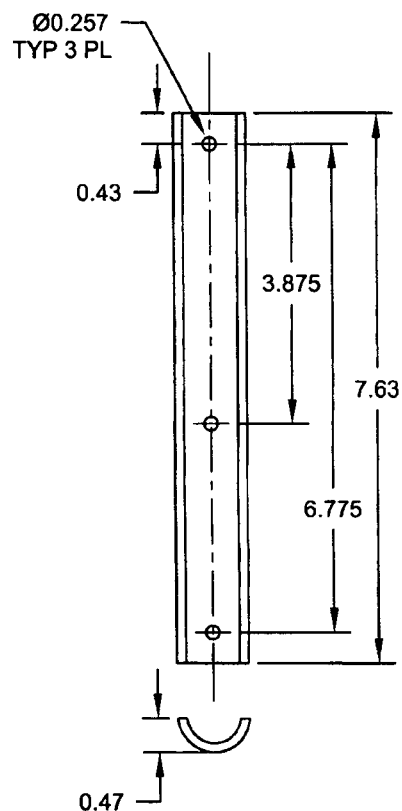
PURPOSE:

TO REVISE D3016-11 SADDLE'S HOLE SIZES

CHANGE:

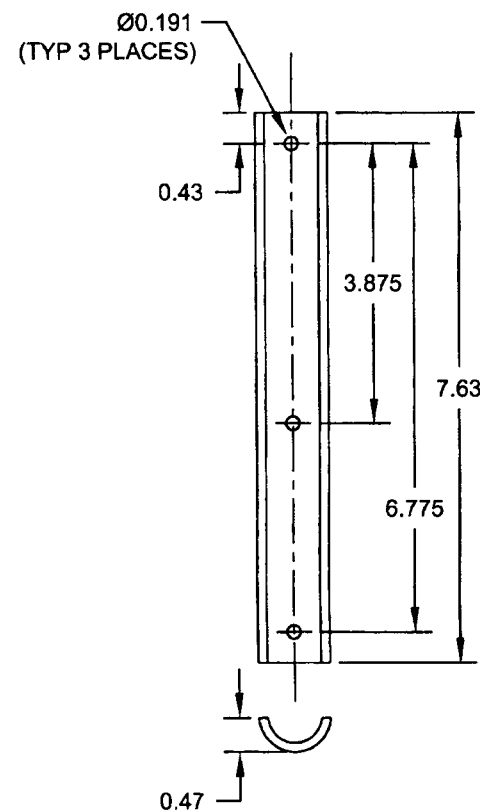
DETAIL D3016-11 SADDLE (SHEET 3): Ø0.257 TYP 3 PL WAS Ø0.191 (TYP 3 PLACES) AS SHOWN:

IS:



D3016-11 SADDLE

WAS:



D3016-11 SADDLE

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